

002697



Dart Aerospace Ltd.
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D407-547-047
Job Sheet 174548



Part No: D407-547-047

Job Qty: 2 ea

Part Name: Console High Slope



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/16/18

Job Tracking No:

Due Date: 4/18/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG D206-547 REV F Sheet 1,5 IPP Rev: 06-01-05 Removed Packing Kit JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	4/17/18	4/17/18	0.00	0.00	Start Up Small Fab-3		
100	Small Fab	2 pcs	4/17/18	4/17/18	0.00	1.85	Small Fab-5		
130	QC	2 pcs	4/17/18	4/17/18	0.00	0.00	QC5		
140	Large Fab	2 pcs	4/17/18	4/17/18	0.00	0.78	Large Fab 2		
150	QC	2 pcs	4/17/18	4/17/18	0.00	0.00	QC10		
160	Small Fab	2 pcs	4/17/18	4/17/18	0.00	1.85	Small Fab-5		
170	QC	2 pcs	4/17/18	4/17/18	0.00	0.00	QC5		
180	Powdercoat	2 pcs	4/18/18	4/18/18	0.00	0.31	Powdercoat4		
190	QC	2 pcs	4/18/18	4/18/18	0.00	0.00	QC3		
200	Packaging	2 pcs	4/18/18	4/18/18	0.00	0.00	Packaging3-2		
210	QC21-FG	2 Ea	4/18/18	4/18/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates DT 8264-1, Descriptions: DT 8264-2, DT8264-3, DT8264-4 2-Deburr 3-Grind weld relief chamfer as per Dwg D206-547 4- Clean rails with ultra bright aluminum cleaner before riveting 5- Rivet extrusion to sides as per Dwg D206-547 using Rivet MS20470AD3-4
140 - 1-Weld as per Dwg D206-547 A/R AL ROD Batch: 2-Grind weld as per dwg D206-547
160 - 1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3
180 - START TIME: 8:20 OVEN TEMPERATURE: 320° FINISH TIME: 9:05.

M 136700

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2024	Extrusion (\$ Per Square Foot)	6.8400 Ea (3.42 ea)	90-Start up Operation	FI-1
D2604-1	Console Side LH, 407 Console	2 Ea (1 ea)	100-Small Fab	5037715
D2604-2	Console Side RH, 407 Console	2 Ea (1 ea)	100-Small Fab	5037710
D2606	Console Bracket, 206/407 Console	2 Ea (1 ea)	100-Small Fab	5055233
D2608	Bracket, 407 Console	2 Ea (1 ea)	100-Small Fab	5049924
MS20470AD3-3	Rivet, Universal Head	12 Ea (6 ea)	100-Small Fab	F1065
MS20470AD3-4	Rivet, Universal Head	40 Ea (20 ea)	100-Small Fab	FMI36851-1

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2024	7	998	0
100-Small Fab	D2604-1	2	3	0
	D2604-2	2	3	0
	D2606	2	5	0
	D2608	2	0	0
	MS20470AD3-3	12	5,714	0
	MS20470AD3-4	40	6,971	0
Part Specifications				
Specifications could not be found.				

Plex 3/16/18 4:04 PM Dart.Gagnon.Michelle



Container No: S063704



Part: D407-547-047

Job No: 174548

Serial No/Batch: S063704

Revision: F

Inspector:

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